Quality Control

Page 1

January-11-13 8:37:07 AM Item ID: D3891-041 Accept *N900040100* Setup Start Revision ID: Panel. Fwd LH Item Name: Start Date: 1/11/13 Start Otv: 4.00 Cust Item ID: Required Date: 1/25/13 Req'd Otv: 4.00 Customer: Reference: Run Start Process Plan: ML5 Date: 13-01-11 Tooling: Approvals: Date: Stop QC: _____ Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Run Hours Qty Qty Code Number Stamp Draw Nbr **Revision Nbr** D3891 Α 100 0.00 *100* B13-1-27 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3891-1 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 服(3:1-か) QC

0.00

Memo

											DQA:	Da	ate:	
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Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

*14*****
Packaging

Packaging

January-11-13 8:37:07 AM Item ID: D3891-041 Accept *N900040100* Setup Start Revision ID: Item Name: Panel, Fwd LH **Start Date:** Start Oty: 4.00 1/11/13 **Cust Item ID:** Required Date: 1/25/13 **Reg'd Oty:** 4.00 **Customer:** Reference: Run Start Process Plan: Date: Approvals: Tooling: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Run Hours Work Center ID Description Code Qty Number Stamp Oty 120 OC8- Inspect parts - second check *120* OC 0.00 13. 1. 28 Memo Quality Control 130 0.00 *130* Small Fab 0.00 Memo Small Fab Deburr if necessary 140 Pick Kit 0.00

0.00

Memo

NCR: Y	es / No				WORK ORDER NON-O	CON	NFORM	MANCE / UPI	DATE		_	
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Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 3

January-11-13	8:37:07 AM				·						
Item ID: Revision ID: Item Name:	D3891-041 Panel, Fwd L	н		Accept	*N90004	4010C) *	Setup	Start Stop	*N!	S1* S2*
Start Date: Required Date Reference:	1/11/13 : 1/25/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:					IV.	
Approvals:	Process Pla	an:	Date:	Tooling:	Date:	 	I	Run	Start	*N!	R1*
	QC:		_ Date:	SPC (Y/N):	Date:_				Stop	*NI	R2*
Sequence ID/ Work Center I 150 *150* Small Fab Small Fab Small Fab 160 *160* QC Quality Control	D	Memo I- Bond gas A/R 3M 13 QC5- Inspect part comple	ket to smooth side of pane 300 adhesive Batch: M (eteness to step on W/O	Set Up/ Run Hours 0.00 0.00 1 as per dwg 2 4 2 9 7 0.00 15	Tool ID To	ool# Plan Code	Accept Qty	Reje Qty		Reject Jumber	Insp. Stamp
170 Packaging Packaging		Identify as per dwg & St Memo	ock Location: PN 95531 94	0.00 0.00 7301A				*: - 	<u>//</u> 3) sf	4 (4)

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Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Quality Control

95542

January-11-13	8:37:07 AM	1		. , , , ,							
Item ID: Revision ID: Item Name:	D3891-041		1	Accept	*N900	040	100)* s	etup Star Stoj	1/1	S1*
Start Date: Required Date Reference:	1/11/13 e: 1/25/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				10	.7/
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:		R	tun Star Sto	"IV	R1*
Sequence ID/ Work Center I	ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*180 *180*		QC21- Final Inspection	- Work Order Release	0.00					13	12/1	1 \$
QC		Memo		0.00							' - ' ()

me 13-2-14

NCR:	Yes	/	No

Date:

DQA:

NCR:	Yes	/ No				WORK ORDER NON-O	CON	FORN	1ANCE / UP	DATE			
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		Wave/Tw			·	Folio	-		Dimensions				

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Picklist Print

January-11-13 8:37:11 AM

Work Order ID: 95542

95542

Parent Item:

D3891-041

D3891-041

84107

Parent Item Name: Panel, Fwd LH

Start Date: 1/11/13

Required Date: 1/25/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No		- 	100	sf	335.0613	4.656	19.60421			
MI FXS 1 GE PLASTICS LEXAN SH		N29-N4 []	۲						**		B13.	トンフ	
				Location		<u>Loc</u>	<u>Qty</u>	Loc Code					
				MAT019			0613			0 (\$7.5			
D3891-3					121803		0613		· <u>7</u>	31803			
	•	Manufactured	No			140	Each	2.0000	. 1	4	•		
*D3891-3 ³ Gasket	ĸ								**		_ F	F 1	3-02
				Location		Loc	<u>Oty</u>	Loc Code					
				ST416	95543		2			2			

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Work Orde	er.					DISPOSITION				AGAINST DE	PARTI	NENT	/PROCESS		
Part NCR I	- No					Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Re		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	Ţ	Initial	Ac	tion	Sign	ո &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription	Da	te	Verification	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
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Landi		ear Bending Centre No Cracks Crushed/ Cuffs Heat Trea	Crimped. at		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		-1	on Incomplete ions Incomplete/ nance led	Unclear	Part II Part L Part N	Under ncorre ost/M Moved oned N	lissing		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
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Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95542
Description: Panel	Part Number:	D3891-1
Inspection Dwg: D3891 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

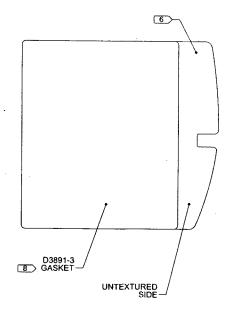
X First	Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.84	+/-0.030	2.84	_		7 (Ba)	
26.4	+/-0.100	26.4	l		7	
24.5	+/-0.100	24.5	9		T	
25.4	+/-0.100	24.4	U		7	
22.5	+/-0.100	7.66	5		7	
26.2	+/-0.100	26.2	U		٢	
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0.125	+/-0.010	דכון	>		V 1802	
						
		,	2AC			

		<u> </u>		
Measured by: 🖟	Audited by:	15	Prototype Approval:	N/A
Date: 13-1-27	Date:	13-12,50	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	09.07.29	New Issue	P/O D3891-041	KJ 🚧	T M
				• • • • • • • • • • • • • • • • • • • •	

PARTS LIST QTY ITEM P/N DESCRIPTION -041 D3891-041 PANEL, FWD LH D3891-1 PANEL D3891-3 GASKET A/R 3M 1300 **ADHESIVE** 26.4 REF - 21.0 REF --



SHOP COME RETURN (O) ENGINEET G UNCONTROL! !! SUBJECT TO ACTA WITHO NO 95542 MLJ 13-01-11

D3891-041 PANEL, FWD LH

25.4 REF

В

-D3891-1 PANEL

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART

ON SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES 7) WEIGHT: 3.67 ibs 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

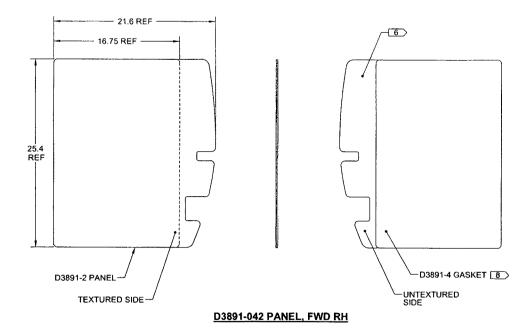
Α	NEW ISSUE			CP	09.05.01
REV.		DESCRIPTION		BY	DATE
DESIG	N	a	DART AEROSPACE LTD		TD
DRAW	N.	0	HAWKESBURY, ONTARIO, CANADA		
CHEC	(F)	PH ,	DRAWING NO. REV. A		REV. A
MFG.	APPR.	Just	D3891 s _H		SHEET 1 OF 6
APPRO	OVED	D TITLE		SCALE	
DE APPR.		-	PANEL, FWD		NTS
DATE 09.05.01			COPYRIGHT © 2009 BY D		

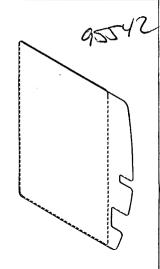
TEXTURED SIDE

3

PARTS LIST

ITEM	QTY -042	P/N	DESCRIPTION	
1	X	D3891-042	PANEL, FWD RH	
2	1	D3891-2	PANEL	
3	1	D3891-4	GASKET	
4	A/R	3M 1300	ADHESIVE	





С

NOTES:

1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART

ON SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES

7) WEIGHT: 2.93 lbs 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	9		
CHECKED	Rt 1	DRAWING NO.	REV. A
MFG. APPR.	J.H	D3891	SHEET 2 OF 6
APPROVED	ANA	TITLE	SCALE
DE APPR.	11-	PANEL, FWD	NTS
DATE 09.0	05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS FROM THE AND CONTRIBUTION, MAD IS SUPPLED ON THE EXPRESS CONTRIBUTION THAT IT IS NOT TO BE LISED FOR MY PURPOSE OR COOPED OR COMMANDANTED TO MY CHIEF PERSON WITHOUT	

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